121423

Page 1

Thursday, June 26, 2014 2:59:20 PM Accept Item ID: D2565-101 *N900040100* Setup Start **Revision ID: Item Name:** Strut Start Oty: 5.00 **Start Date:** 6/26/14 **Cust Item ID:** Required Date: 6/26/14 Req'd Qty: 6.00 **Customer:** Reference: Start Run Process Plan: MLJ Date: 14-00-23 Tooling: Date: **Approvals:** Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Accept Reject Reject Insp. Set Up/ Qty Number Stamp **Work Center ID Description** Code Oty **Run Hours Revision Nbr Draw Nbr** D2565 Rev E 1469h3 Punch ends and deburr as per dwg 0.00100 DAS NC BRAKE 30 10 *100* Brake NC 0.00 Memo Punch as per Dwg D2565 using DT 8313 Brake NC $\alpha = \{1, \dots, n\}$ 0.00 110 Small Fab *110* Small Fab 0.00Memo Drill hole open to .316 Ø as per Dwg D2565 (one end only) Small Fab Deburr DAS. 120 QC5- Inspect part completeness to step on W/O 0.00 10 *120* 0.00Memo Quality Control

DQA:	Date:												PART
						WORK ORDER NON	-CC	NFOF	RMANCE / UI			,	AEROSPACE
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		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ci	Temperature/Cure
	Г	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
	一	Cuffs		•		Contamination		4 '	tions Incomplete/l		Part Moved		Wrong Stock Pulled
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Work Order ID 121423

121423

Page 2

26, 2014 2:5	9:20 PM		" >	147.5"								
D2565-101 Strut			Accept	*N900	040	100)*	Setup	Start Stop			
6/26/14 : 6/26/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:							
Process Pla	nn:	Date:	Tooling: SPC (Y/N):				F					
D	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty			Insp. Stamp	
	Memo START TIM OVEN TEM	16: 1135460 Iperature: 460	0.00				10	8	/7	1-9-,	<u>H. </u>	DAS 34
	QC3- Inspect Part Finish Memo		0.00				10				DAS 38 9-89	<u> 1</u> 4-9-
	Identify as per dwg & Sto	ock Location	0.00				/0x		{	DL'	J_9	-5
	D2565-101 Strut 6/26/14 6/26/14 Process Pla QC:	Strut 6/26/14 Start Qty: 6.00 Process Plan: QC: Operation Description White Gloss(Ref:4.3,5.2) Memo START TIM OVEN TEM FINISH TIM QC3- Inspect Part Finish Memo Identify as per dwg & Ste	Strut 6/26/14 Start Qty: 6.00 *6* 6/26/14 Req'd Qty: 6.00 *6* Process Plan: Date: QC: Date: Operation Description White Gloss(Ref: 4.3.5.2) per QS1005 4.3-Steel Memo START TIME: // John Color TEMPERATURE: FINISH TIME: // John Color Temperature: FINISH TIME: // John Color Temperature: //	D2565-101 Accept	D2565-101	D2565-101 Accept	D2565-101 Accept	Description Set Up Tool ID Tool # Plan Accept	D2565-101	D2565-101	D2565-101	D2565-101

DQA:		Date:			WORK ORDER NON	~	NEOE	DAANICE / II	DDATE				DART
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Work Ord Thursday, June				*12			Page 3					
Item ID: Revision ID: Item Name:	D2565-101	I		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date	6/26/14 e: 6/26/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
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1 AN QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00				ML	3	_/4	-90-19 W	

DQA:		_ Date:											"DART
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Part N	lo				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
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	Crimp/Ki	nk/Ripple	e/Wave		Burrs	<u></u>	1 '	ion Incomplete/Ur		_	Part Lost/Mi	issing	Weld
	Cuffs				Contamination	\perp	4	tions Incomplete/l	Inclear		Part Moved	L	Wrong Stock Pulled
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' Picklist Print

Thursday, June 26, 2014 2:59:19 PM

Work Order ID: 121423

Parent Item Name: Strut

121423

Parent Item:

D2565-101

D2565-101

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	568.7261	1.71	11	DAS	3	1 1
*M304TR0	750W	049 *							**		30 9-89		4/09/03

304 RD Tube .750 x .049W

Location	Loc Qty	Loc Code	
MAT017	568.7261		
122312	4.04		
124768	49.27		
M126183	1.4399		
M128084	38.9762		
M129188	75		_/3
M129363	400		

DQA:		Date:										"DART
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	Cracks				Broken/Damage/Defect		Hardwa		ļ	Part Incorre	-	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs	Ĺ	4 .	ion Incomplete/Ur	· -	Part Lost/M		Weld
	Cuffs				Contamination	L	4	tions Incomplete/U	Jnclear	Part Moved	_	Wrong Stock Pulled
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Wave/Twist in Tube				Fit/Function	Out of Sequence							

DART AEROSPACE LTD	Work Order: /2/423
Description: Shut	Part Number: 7 256 t - 101
- Julion -	
Inspection Dwg: DDSC Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of inspection	Comments
20.52	+1030	20.53			7	\$ -B
19.72	11-030	19,73	/		V	B-5
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Measured by:	30 9-89	Audited by:	SVO	Preliminary Approval:	
Date:		Date:	19/09/03	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15